

Work Order ID **164447**

164447

Page 1

Wednesday, July 19, 2017 2:34:47 AM

Item ID: D4726-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Handle
 Start Date: 7/18/2017 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 7/28/2017 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 9-89 Date: JUL 20 2017 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4726	B

100	Cut blanks as per folio	0.00							
100									DAS 08 9-89
Bandsaw	Memo	0.10	B.A	17-08-09		4	φ		
Jeaspa Bandsaw	CUT BLANK AT 1.800"								

110		1.46							
110									DAS 08 9-89
HAAS 5AXIS	Memo	1.05	B.A	17-08-09		4	φ		
HAAS CNC vertical machine #5	MACHINE AS PER DWG & FOLIO FB132								
	FOLIO REV: <u>AA</u>								
	DWG REV: <u>B</u>								

DEBURR

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY								
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

Work Order ID 164447

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Page 2

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120	QC2- Inspect parts off machine FAI/FAIB	0.00							
-----	---	------	--	--	--	--	--	--	--

120

QC

Memo

Quality Control

0.04

D.e 17-08-09

4

φ

DAS
08
9-89

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

Quality Control

0.08

4

φ

DAS
14
9-89

17/08/19

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

164447

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N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:
Customer:

Start Date: 7/18/2017 **Start Qty:** 4.00 ***4***

Required Date: 7/28/2017 **Req'd Qty:** 4.00 *** 1 ***

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

Set Up/
Run Hours**Tool ID****Tool #****Plan
Code**

**Accept
Qty**

Reject Qty

Reject
Number

**Insp.
Stamp**

132

Outsource process-Anodize per QSI017 4.1.10.1

0.00

132

Outsource4

Outsource process - Anodize

Memo

Issue P/O to ATG:

720.00

- ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 as per dwg.

- Certification of Conformity is required

WAB

DAS
13
9-89

4

AUG 25 2017

134

Receive & Inspect for Damage & Mat'l Certs

0.00

134

Packaging

Packaging

Memo

0.08

4x8079-6

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
136 *136* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.04			DAS 30 9-89	<u>4</u>			SEP 07 2017
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>2112</u> Memo	0.00 0.04				<u>4</u>			SEP 07 2017 DAS 6 9-89
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.40							17/9/8 DAS 21 9-89 SEP 07 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
241 08 28-8								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER :							
Misidentified ☐	☐ Past Due								

Picklist Print

Wednesday, July 19, 2017 2:34:50 AM

Page 1

Work Order ID: 164447

164447

Parent Item: D4726-1

D4726-1

Parent Item Name: Handle

Start Date: 7/18/2017

Required Date: 7/28/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 12.10.16 AS PER DWG REV.A DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X02.00 0		Purchased	No			100	f	11.6184	0.15	0.631579			

M6061T6B0 750X02 000

6061-T6 Bar .750 x 2.00

**

5. 17-08-09

Location

Loc Qty

Loc Code

MAT

1.16

→ m136463

1.16

MAT003

10.4584

→ m137175

10.4584

1.160ft

0.3445ft

DQA: _____ Date: _____



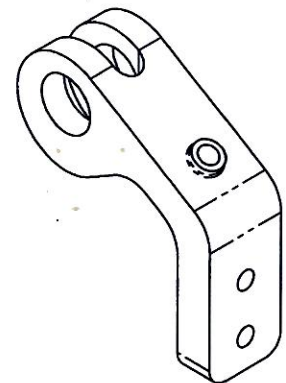
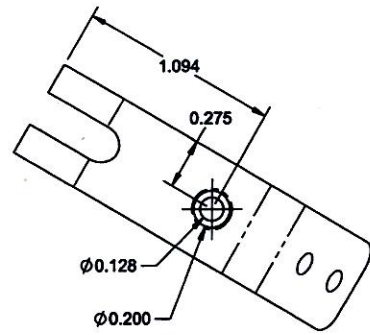
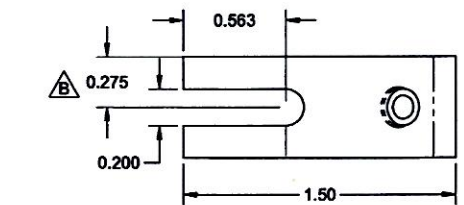
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

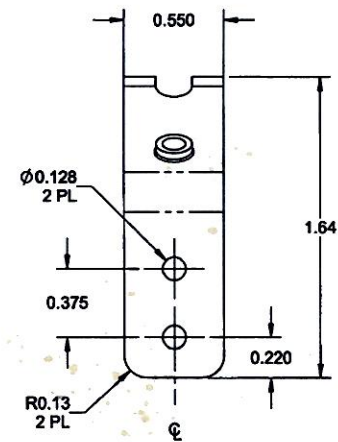
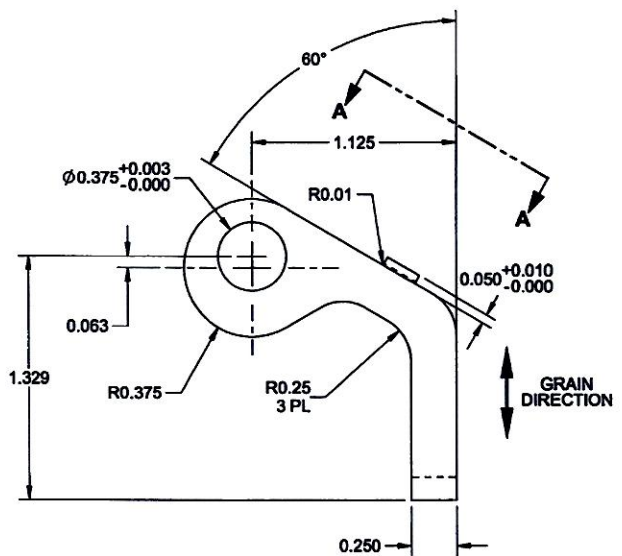
Work Order update only ☐

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								Completed By 	
								Lead hand / Supervisor Approval Verification 	
								QC / QA Coordinator Approval 	

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
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Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						



VIEW A-A



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 164447 MS
170720

D4726-1 HANDLE

RELEASED
2017 MAY 24
ECN 17-571

- NOTES:**
- 1) MATERIAL: ALUMINUM, 6061-T6/T651 PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221
 - 2) FINISH: BLACK ANODIZE PER MIL-8625F, TYPE III, CLASS 2
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4726-1" AND B/N "BXXXXX" PER QSI 044 6.7
 - 7) WEIGHT: 0.04 lbs
 - 8) ALL NON DIMENSIONED FEATURES PER DWG FILE "D4726-1-REV.B.STP"

B	ADDED VIEW A-A AND HOLE FOR D4704-043, ADDED DIMENSION ZN D7-1	VS	17.02.02
A	NEW ISSUE	RP	12.09.19
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	VS		
CHECKED	WK	DRAWING NO.	REV. B
MFG. APPR.	DD	D4726	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	HANDLE	NTS
DATE	17.02.02	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

APPROVED



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO37552

Purchase Order Date 8/25/2017

PO Print Date 8/29/2017

Page Number 5 of 7

Order From :

VC-ATG001

Ship To : DART AEROSPACE LTD

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613-446-4544

Ship To Contact

Ship To Phone

Ship Via:

VENDOR'S TRUCK

Ship Acct:

Buyer

Diane Baker

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

11	165197	647.0111 Panel	9/13/2017	13.00	\$39.25	\$510.25
			Yes			
			9/13/2017			

As per Dwg 647.0100

Rev. A1

Hard Anodize IAW MIL-A-8625F, Type III, Class 2, Color Black; Prime IAW MIL-PRF-23377, Type I, Class N

Line Total: \$510.25

12	163964	D5532-041 Valve Cap Assembly	9/13/2017	11.00	\$13.64	\$150.00
			Yes			
			9/13/2017			

Blue Anodize as per Dwg D5532

Rev. A

Anodize Blue per MIL-A-8625F Type 1 or IB or IC or II or IIB, Class 2

Line Total: \$150.00

13	164447	D4726-1 Handle	9/13/2017	4.00	\$2.70	\$10.80
			Yes			
			9/13/2017			

As Per Dwg D4726 RevB

Black Anodize Per MIL-8625F, TYPE III, CLASS 2

80 A-9-6

PO Instructions: PRIMER IS SUPPLIED BY DART

Note:

8/29/2017



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 913773

Date: 01-Sep-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
10 ea	Part: 647.3917 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 21621	Rev: C2 PO: PO37552 Line: 1	
4 ea	Part: D4726-1 Handle Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils). Job: 21633	Rev: B PO: PO37552 Line: 13	SPR-9-6
12 ea	Part: D4726-1 Handle Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils). Job: 21634	Rev: B PO: PO37552 Line: 14	
10 ea	Part: D2348 Wearplate (Key Way) Black Anodize per MIL-A-8625F, Type II, Class 2, .0004-.0010" (.4 - 1 mils). Job: 21635	Rev: C PO: PO37552 Line: 15	
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: 01/09/2017 Certified Signature: Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Made in Canada.			



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 913773

Date: 01-Sep-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms	Ship Via
	OUR TRUCK
Quantity	Description
	Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.
	<i>Sept 9-16</i>
	Made in Canada.